	Work Order ID 76233  Monday, November 07, 2011 2:45:08 PM			*762	233*							Page 1
Revision ID:	190-1		1	Accept	*N900	0040	100	ገ*	Setup	Start	1.71	S1*
		eq'd Qty: 40.00	*40* *40*		Cust Item Customer:						· IN	S2*
Approvals: Pro	ocess Plan: _		Date://-//-// 7	Tooling: SPC (Y/N):		oate:				Start Stop	I <i>A</i>	R1* R2*
Sequence ID/ Work Center ID		eration scription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision	n Nbr										
D3490	Rev A											4 .
*100  *100* Hardinge Hardinge CNC Lathe Sma		rdinge CNC LATHE S Memo 1-TURN AS FOLIO REV	PER FOLIO FA628 & DW	0.00 0.00 G D3490				40	0		of	SS 11/11/1
110 *110* QC Quality Control	QC:	DWG REV:	AS REQUIRED	0.00				40	0		SWK .	1 14 w/w/s
120 *120* QC Quality Control	QC	8- Inspect parts - seco Memo	nd check	0.00	s usus	18		40	<u>)</u> _g	<u> </u>		

W/O:			W	ORK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·							
Part No		PAR #:	Fault Cat	egory:	NCR: Yes	No DQA	\:	Date:	
		esolution:							•
NCR:			WORK ORE	DER NON-CONFORMA	NCE (NCF	1)			
DATE	STEP	Description of NC Corrective Action			on B	Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
				1					
•	ā			,					1
:"									

	Work Order ID 76233  Monday, November 07, 2011 2:45:08 PM			*76233*								Page 2
Item ID: Revision ID: Item Name:	D3490-1 Cross Bolt Sp	acer		Accept	*N900	040	100	)*	Setup	Start Stop	1/1	S1* S2*
Start Date: Required Date: Reference:	11/7/2011	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I	ID:					IN	.7/
Approvals:	Process Pla	ın:	Date:	Tooling: _	D	ate:			Run	Start Stop	17	R1*
	QC:		Date:	<b>SPC (Y/N):</b>	D	ate:				Stoh	*N	R2*
Sequence ID/ Work Center II	D	Operation Description Identify as per dwg & Sto	ock Location:	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt		Reject Number	Insp. Stamp
*130* Packaging Packaging		Memo ***STOCK I	IN SKIDTUBE CELL***	0.00				40		<u> </u>	BC,	11-17-10
140		QC21- Final Inspection -	Work Order Release	0.00							in la	bida
*140* QC Quality Control		Memo		0.00							VI IVI	121 78)

R(1/1/2/8)

W/O:			WC	ORK ORDER CHANG	GES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			,						
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
	Re	esolution:	Dispositio	n:	QA: N/C C	losed:		Date:	
NCR:		1	WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC Corrective Action			tion B	Verifi	cation	Approval	Approval
DAIE	SIEP	Section A	initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
•									
									!

**Picklist Print** 

Monday, November 07, 2011 2:45:12 PM

Work Order ID: 76233

\*76233\*

Parent Item:

D3490-1

\*D3490-1\*

Parent Item Name: Cross Bolt Spacer

Start Date: 11/7/2011

**Required Date:** 11/16/2011

Page 1

**Start Qty: 40.00** 

Required Qty: 40.00

Comments:

IPP Rev:A

New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.049		Purchased	No			100	f	260.8735	0.266	11.2		1	
*M6061T6	STO 500	W 049*	•						**	11.000		St	11/11/17

### ^1\/160611610500\\\049

6061-T6 RD Tube .500 x.049W

Loc Code Location Loc Oty 260.873481 MAT014 11,000 260.873481

W/O:			W	ORK ORDER CHANG	ES				ųħ.
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			- <del></del>						
Part No		PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _	J
	R	esolution:	Dispositi	on:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORE	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Corrective Action			on B	Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
				,					

DART AEROSPACE LTD	Work Order:	76233
Description: Crossbolt Spacer	Part Number:	D3490-1
Inspection Dwg: D3490 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500	+0.006/-0.001	00.500	<b>/</b>		SLOP	
0.049	+/-0.010	0.049	J,		VI	
Ø0.402	+0.006/-0.001	\$ 0.403			l l	- 4
3.085	+0.030/-0.000	3.100	1		c <sub>l</sub>	
).050 x 45°	+/-0.010	0.050X45°			h	
····						
-						\
- 11						

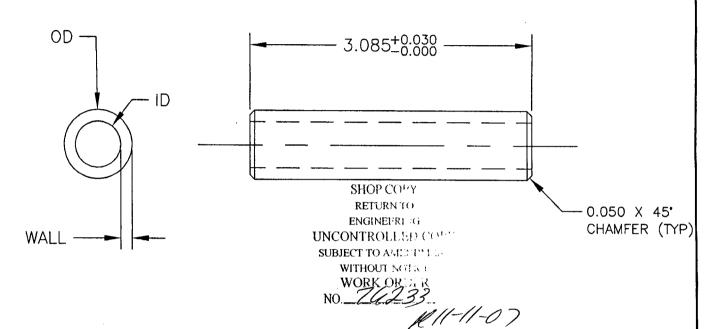
Measured by:	long	Audited by:	12	Prototype Approval:	N/A
Date: 71/11/	17	Date:	1111/8	Date:	N/A

Re	∨ Date	Change	Revised by	Approved
Α	06.10.06	New Issue	KJ/JLM	
В	08.06.02	Dimensions and tolerances revised	KJ/DD LA	
С	08.10.07	0.050 x 45° dimension revised	KJ/DD	787

W/O:			WC	ORK ORDER CHANG	ES					
DATE	STEP	PRO	PROCEDURE CHANGE	NGE	Е	у	Date	Qty	Approval Chief Eng /	Approval QC Inspector
		<u> </u>							Prod Mgr	
<u>.</u>		, Alpha Alph					····			
Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N	lo <b>DQ</b>	A:	Date:	
	Re	solution:	Disposition	n:	_ QA: N	C Clo	sed:		Date: _	
NCR:		,	WORK ORDI	ER NON-CONFORMA	NCE (I	NCR)	<u> </u>			:
		Description of NC	of NC Corrective Action Section B				Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti		Chief Eng	QC Inspector
	<del> </del>									



DESIG	PH	DRAWN BY	DART AEROSPACE	
CHEC	KED #	APPROVED	drawing no. D3490	REV. A SHEET 1 OF 1
DATE			TITLE	SCALE
06.0	01.04		CROSS BOLT SPACER	NTS
Α		06.01.04	NEW ISSUE	



#### D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

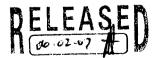
PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

#### D3490-1/-3/-5 CROSS BOLT SPACER

1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)

2) ALL DIMENSIONS ARE IN INCHES

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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W/O:		Maria Ma	WC	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						<del></del>			
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:				
Resolution:			Disposition	QA: N/C C	QA: N/C Closed:			Date:	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCF	₹)			÷
DATE	STEP Descriptio	Description of NC		on B	Veriticati		Approval	Approval	
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
							:		
,									